



Dart Aerospace Ltd.
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D5622-3

Job Sheet 196576



DAG
21
9-89

Part No: D5622-3

Job Qty: 9 pcs

Part Name: 429 - MID Wearpad - OEM Replacement - Standard - LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/17/19

Job Tracking No:

Created By: Linda Lacelle

Due Date: 6/20/19

Type: SOLD

Description:

Note: DWG.D5622 REV.B IPP REV:A NEW ISSUE 18/05/16 JFS VERIFIED BY:DD IPP REV:B 18.11.26 AS PER
DWG REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	9 pcs		6/20/19	0.17	0.56	Waterjet - Flow		JRB
120	QC 2	9 pcs		6/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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P.T.O.

NCR: 19-7856

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB
130 QC 8	9 pcs	6/20/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	JUN 18 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
				QC 8 - 57	
140 Small Fab - Brake NC - B4B	9 pcs	6/20/19	0.25 0.08	Small Fab - Brake - 1 - B4B	
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	9 pcs	6/20/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	JUN 19 2019 40
					9-89
160 Automated Welding - B4B	9 pcs	6/20/19	0.00 0.28	Automated Welding - 1 - B4B	MAZ
170 QC 10	9 pcs	6/20/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	PL

180 QC 5	9 pcs	6/20/19	0.00 0.00	QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	RE
				QC 5 - 30	
				QC 5 - 40	
190 Handfinish - 4-1-Assembly-B4B	9 pcs	6/20/19	0.00 0.24	Handfinish - 4 - 1 - B4B	RD 19-6-19
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
200 QC 3	9 pcs	6/20/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	DAS 40 JUN 20 2019 9-89
				QC 3 - 19	
				QC 3 - 43	
210 Packaging 3-1 - Stock - B4B	9 pcs	6/20/19	0.00 0.00	QC 3 - 24	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	

				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
220 QC 21 - SA	9	6/20/19	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	9-89
				QC 21 - SA - 53	
Part Op 110 - 1-Cut D5622-3F as per Dwg D5622 Dwg Rev: B Prog Rev: B 2-Deburr if necessary					
Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB					
130 - QC8- Inspect parts - second check					
140 - Form as per dwg					
150 - QC5- Inspect part completeness to step on W/O					
160 - Automated welding ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: 138901					
170 - QC10- Inspect visual per QSI004- ground welds					
180 - QC5- Inspect part completeness to step on W/O					
190 - Assemble as per dwg - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI BATCH: 5172450					
200 - QC3- Inspect Part Finish					
210 - Identify as per dwg & Stock Location: LOCATION : FP001					
220 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S16GA	304/316 Sheet .063	.9090 sf (.101 ea)	110-Waterjet - Flow - 1	5159674	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Waterjet - Flow - 1	M304S16GA	1	295	0	

Part Specifications
Specifications could not be found.

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Entered: md 8 July 2019 Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. <u>19-7256</u>		Route update only ☐																													
Job: <u>196576</u>		DEPARTMENT/PROCESS																													
Part No. <u>D5627-3</u>		<table><tr><td>Skid-tube</td><td>Eng. (Non-AW)</td></tr><tr><td>Machining</td><td>Prod. Eng. Coord.</td></tr><tr><td>Large Fab</td><td>Rec/Store/Packaging</td></tr></table>		Skid-tube	Eng. (Non-AW)	Machining	Prod. Eng. Coord.	Large Fab	Rec/Store/Packaging																						
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Machining	Prod. Eng. Coord.																														
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DISPOSITION		<table><tr><td>Rework</td><td>Engineering</td></tr><tr><td>Scrap</td><td>Water Jet</td></tr><tr><td>Use-as-is</td><td>Supplier</td></tr></table>		Rework	Engineering	Scrap	Water Jet	Use-as-is	Supplier																						
Rework	Engineering																														
Scrap	Water Jet																														
Use-as-is	Supplier																														
Sequence #: <u>130</u>		QTY Affected: <u>1</u>																													
Date: <u>19/06/18</u>		NRR (QS1042) <u>55</u>																													
Description Work Order Deviation		Completed By <u>July 5, 2019</u>																													
<u>-outside tolerance is too small</u>		<u>40</u>																													
<u>-was cut at end of sheet</u>		Lead hand / Supervisor <u>Jan Luc Menard</u>																													
Root Cause		QC / QA Coordinator <u>68</u>																													
<table><tr><td>Operator</td><td>☒</td></tr><tr><td>Manufacturing Process</td><td>☐</td></tr><tr><td>Equip/Tooling</td><td>☐</td></tr><tr><td>Handling/Preservation</td><td>☐</td></tr><tr><td>Material</td><td>☐</td></tr><tr><td>Product Improvement</td><td>☐</td></tr><tr><td>Process Improvement</td><td>☐</td></tr><tr><td>Human Factors</td><td>☐</td></tr></table>		Operator	☒	Manufacturing Process	☐	Equip/Tooling	☐	Handling/Preservation	☐	Material	☐	Product Improvement	☐	Process Improvement	☐	Human Factors	☐	FAULT CATEGORY													
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		Out of Sequence																													
		Off-set/Set-up																													